



## 20" SINGLE SURFACE PLANER 30-360

## OPERATING MAINTENANCE INSTRUCTIONS



### FEATURES

- Table moves quickly and accurately by a positive gear box.
- 5" dust collection hood.
- Cast iron table and head.
- Four cutter knives result in easier cutting and longer motor life.
- Built in table rollers reduce friction.
- 8" large handwheel quickly adjusts table height.
- Comes with magnetic safety switch.
- Metric and SAE graduation scale to indicate workpiece thickness.
- Anti-kickback fingers are provided in front of the infeed roller to ensure maximum safety for the operator.
- Vertical adjustable handle for table rollers.
- The machine is equipped with a section infeed roller and rubber outfeed roller.
- Equipped with one outside table roller at front.

### SPECIFICATIONS

#### TABLE SIZE

**MAX. PLANING WIDTH**

**MAX PLANING THICKNESS**

**MAX. CUTTING DEPTH** (FULL WIDTH)

**MAX. CUTTING DEPTH** (WIDTH BELOW 215 mm)

**MIN. PLANING LENGTH**

**KNIVES**

**CUTTERHEAD SPEED**

**FEEDING SPEED (2)**

**CUTTERHEAD DIAMETER**

**MOTOR**

**WEIGHT**

#### MODEL

**30-360 / 30-360HC**

**32" x 20" (813 x 508 mm)**

**20" (508 mm)**

**8" (204 mm)**

**1/8" (3 mm)**

**1/4" (6 mm)**

**8 1/4" (210 mm)**

**4 / HELICAL**

**4500 RPM**

**22 FPM, 28 FPM**

**3 6/8" (97 mm)**

**M1 7 1/2 HP, 220 V, 1 Ph**

**M2 7 1/2 HP, 220 V, 3 Ph**

**M3 7 1/2 HP, 600 V, 3 Ph**

**1392 LBS (633 kg)**

# SAFETY RULES

## READ CAREFULLY BEFORE OPERATING THE MACHINE

1. Learn the machine's applications and limitations, as well as the specific potential hazards particular to this machine. Follow available safety instructions and safety rules carefully.
2. Keep working area clean and be sure adequate lighting is available.
3. Do not wear loose clothing, gloves, bracelets, necklaces, or ornaments. Wear face, eye, ear, respiratory and body protection devices, as indicated for the operation or environment.
4. Keep hands well away from blades and all moving parts. Do not clear chips and sawdust away with hands. Use a brush.
5. Make sure the cutters are moving at operation speed before planing.
6. Do not push the cutterhead too hard. The planer will perform better and be safer working at the rate for which it was designed.
7. Whenever possible use a dust collector with shaving hood to minimize health hazards.
8. Never leave the machine with the power on.
9. Keep children away. Make sure that visitors are kept at a safe distance from the work area.
10. Use recommended speed cutters accessory, and workpiece material.
11. Never stand on tool. Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
12. Be sure planer blades are securely locked in the machine.
13. Use suitable support if stock is too long.
14. Do not force the machine. It will do the job better and be safer at a rate for which it was designed.
15. Keep guards in place and in working order. If a guard must be removed for maintenance or cleaning make sure it is properly attached before using the tool again.
16. Be sure that key and adjusting wrenches have been removed before turning power on.
17. Use only accessories designed for the machine.
18. Make sure tool is properly grounded. If tool is equipped with three-prong plug, it should be plugged into a three-pole electrical receptacle. Never remove the third prong.
19. Always disconnect tool before servicing and when changing accessories such as planer blades.
20. Make sure that switch is in "OFF" position before plugging in cord.
21. Place material firmly against the table.
22. Use ONLY recommended accessories. Use of accessories NOT recommended by General International may result in a risk of injury.
23. Do not use this planer for other than its intended use. If used for other purposes, General International disclaims any real or implied warranty and holds itself harmless for any injury, which may result from that use.

## GENERAL ® INTERNATIONAL guarantee

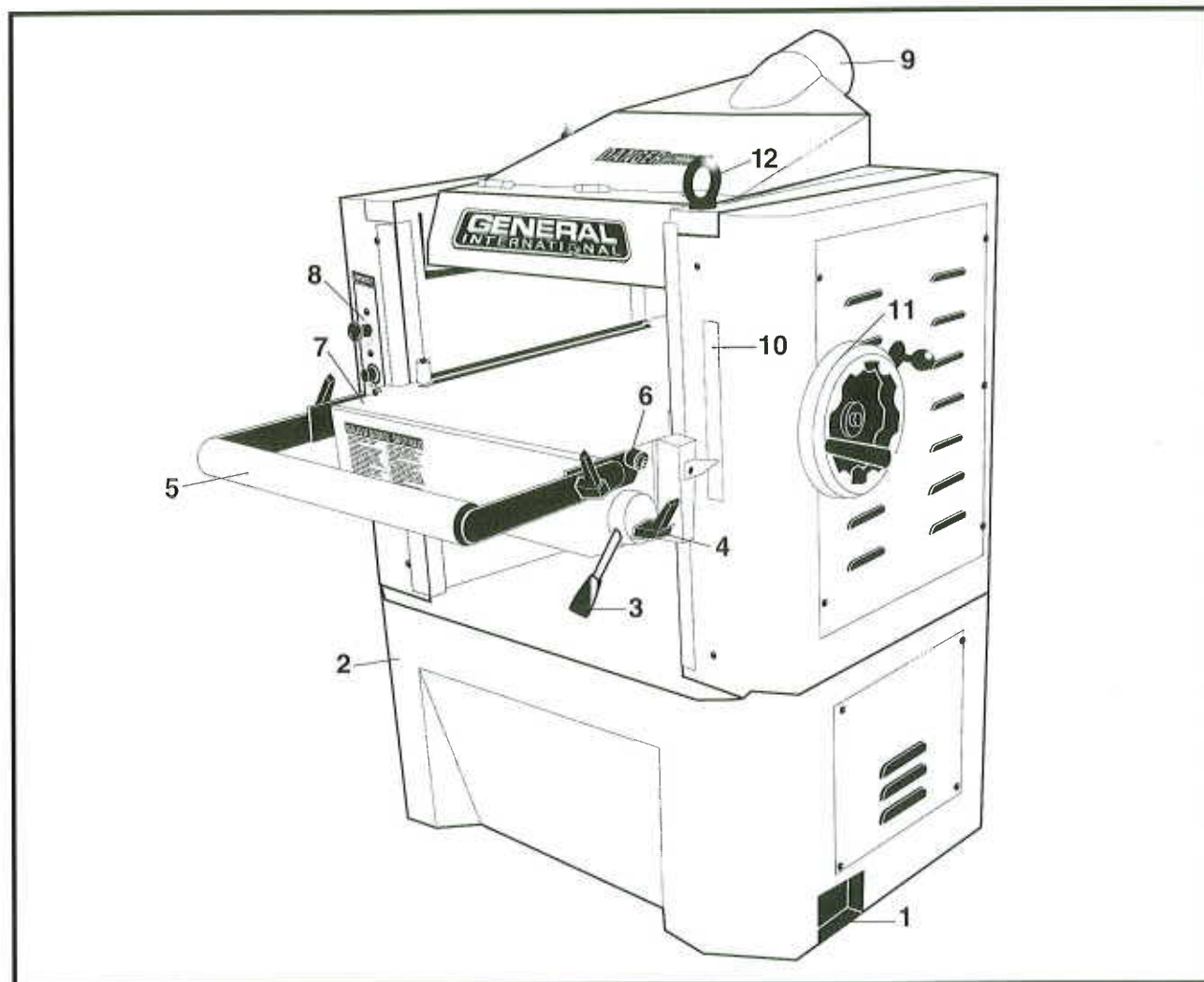
All component parts of GENERAL INTERNATIONAL machinery are carefully inspected during all production stages and each machine is thoroughly inspected upon completion of assembly. Because of quality, GENERAL INTERNATIONAL agrees to repair or replace any genuine part or parts which, upon examination, proves to be defective in workmanship or material within a period of 24 months from date of purchase. In order to obtain warranty, all defective parts must be returned prepaid to GENERAL INTERNATIONAL MFG. Co Ltd. Repairs made without our written authorization voids all guarantees.

## 20" SINGLE SURFACE PLANER 30-360

**GENERAL® INTERNATIONAL** 20" planer 30-360M1, are carefully tested and inspected before shipment and if properly used will give perfect results. However, a reasonable amount of care and attention is necessary to ensure perfect performance and accurate work. It is imperative that you take a few moments to familiarise yourself with these instructions, as they will no doubt save you a lot of time and trouble.



### PARTS IDENTIFICATION



1. LEVELING SCREW
2. STAND
3. CONTROL LEVER
4. LOCK HANDLE
5. EXTENSION ROLLER
6. ECCENTRIC BLOCK
7. MAIN TABLE
8. SWITCH
9. DUST CHUTE
10. DEPTH SCALE
11. UP/DOWN HANDLEWHEEL
12. HOOK

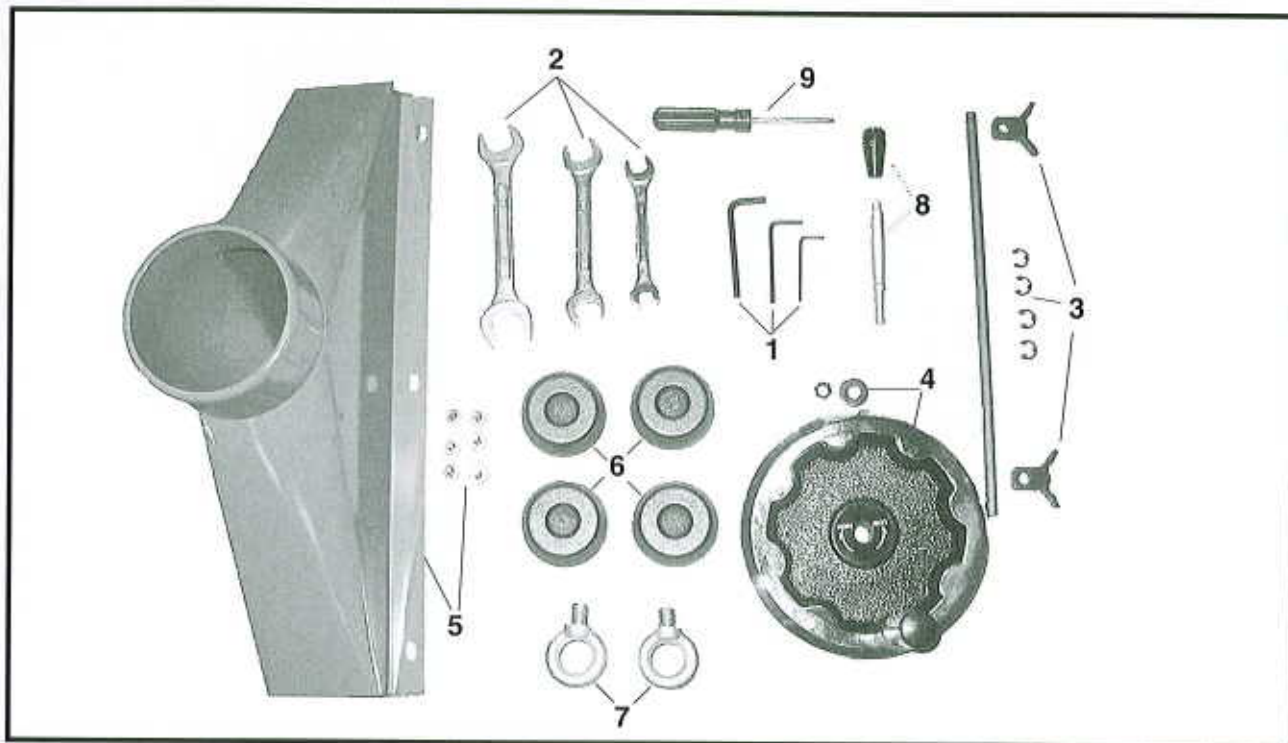


## UNPACKAGE AND CLEANUP

To ensure maximum performance from your GENERAL® INTERNATIONAL 20" planer, clean it properly; and install it accurately before use. As soon as you receive the planer, we recommend you follow these procedures:

1. Finish removing the contents of the shipping wooden case and compare with the contents list.
2. Report damage, if any to your local distributor.
3. Clean all rust protected surfaces with a mild solvent or kerosene. Do not use lacquer thinner; paint thinner, or gasoline. These will damage painted surfaces.
4. To prevent rust, apply a light coating of paste wax to surface.

## CONTENT



### ITEM #1

- (1) 3mm Allen Wrench
- (1) 4mm Allen Wrench
- (1) 6mm Allen Wrench

### ITEM #2

- (1) 8-10mm Open End Wrench
- (1) 12-14mm Open End Wrench
- (1) 17-19mm Open End Wrench

### ITEM #3

- (1) Knife Setting Guide Shaft
- (2) Knife Setting Guide
- (4) "C" Circlip

### ITEM #4

- (1) Handwheel & handle
- (1) Washer
- (1) Nut

### ITEM #5

- (1) Dust Chute
- (3) M5 Hex. Head Screw
- (3) M6 Cap Screw
- (3) Washer

### ITEM #6

- (4) Foot

### ITEM #7

- (2) Hook

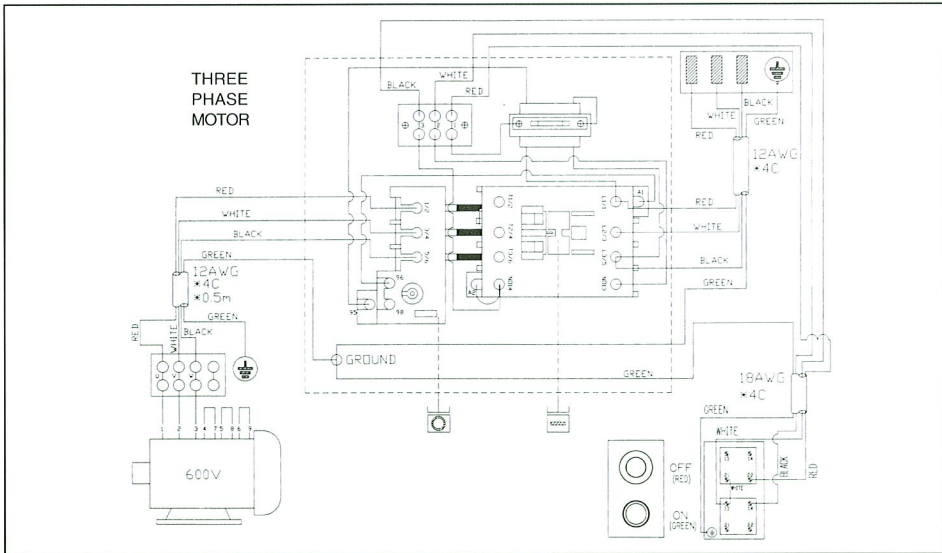
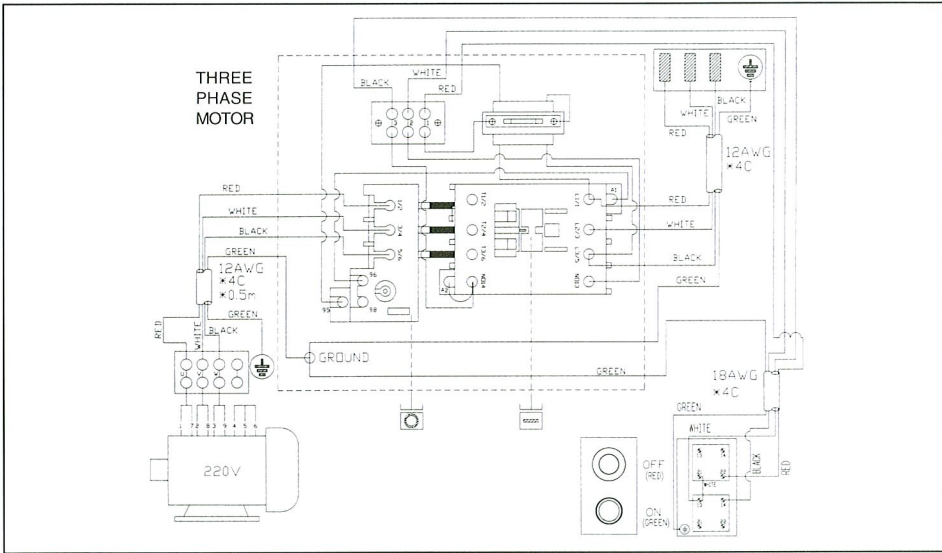
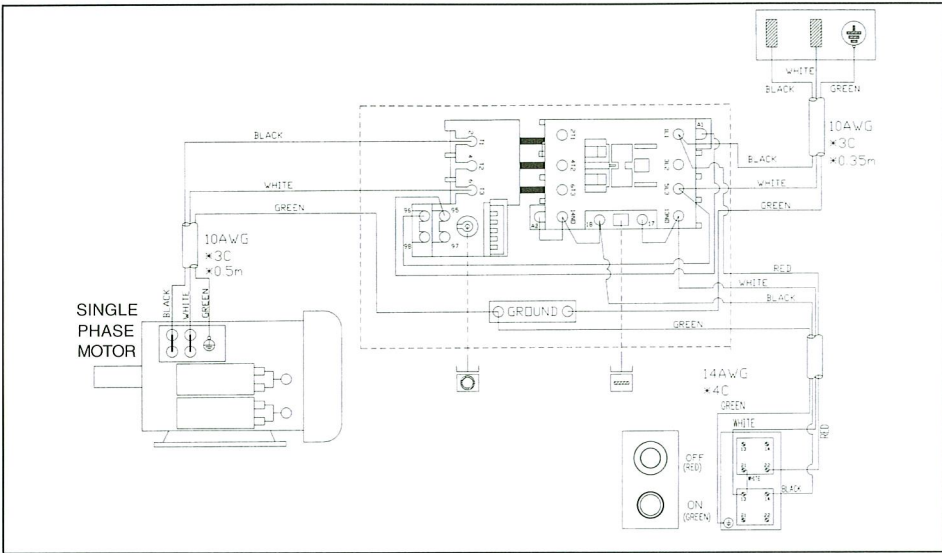
### ITEM #8

- (1) Control Bar

### ITEM #9

- (1) Screw driver

ELECTRIAL SCHEMATIC



## CAUTION!

**NEVER ATTEMPT TO CONNECT TO AN OUTLET WITH A GREATER POWER SOURCE VOLTAGE THAN REQUIRED!**

## ATTENTION!

**ALWAYS VERIFY THAT THE MACHINE IS PROPERLY GROUNDED TO AVOID ELECTRIC SHOCK TO THE WORK OPERATOR!**

### ELECTRICAL REQUIREMENTS

Before connecting the machine to the power source verify that the voltage supplied corresponds as specified on the nameplate of the machine. A power source with greater voltage than needed can result in serious injury to the user as well as damage the machine. If in doubt, contact a qualified electrician before connecting to the power source.

### ELECTRICAL CONNECTION

#### THREE PHASE

1. A four wire cable is equipped in order to connect your machine into the 3 phase power supply. Connect your machine into the power supply with a hand-operated disconnecting device. Such as no fuse breaker or plug/socket combination.
2. In order to protect the control device. We recommend that the operator supply fuse with the appropriate current rating. The total length between the fuse and the connection terminal must not exceed 1.5m.
3. The exact power source voltage, frequency, and number of phase shall be checked according to the installation diagram and circuit diagram.
4. Verify the direction of the cutterhead once connected.

#### SINGLE PHASE

1. A three-wire cable is equipped in order to connect your machine into the single phase power supply. Connect your machine into the power supply with a hand-operated disconnecting device. Such as no fuse breaker or plug/socket combination.
2. In order to protect the control device. We recommend that the operator supply fuse with the appropriate current rating. The total length between the fuse and the connection terminal must not exceed 1.5m.
3. The exact power source voltage, frequency, and number of phase shall be checked according to the installation diagram and circuit diagram.

### GROUNDING

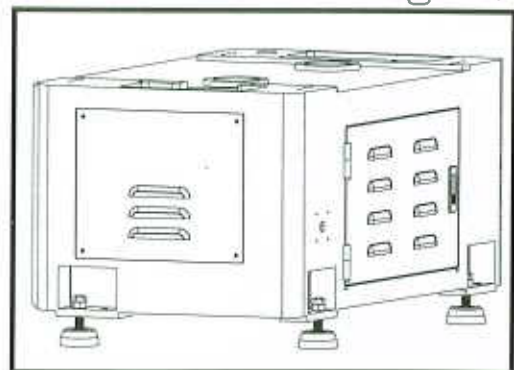
Machine must be properly grounded in order to avoid electric shock to the work operator. The grounding of this model is carried out by connecting the green terminal of supply cable to grounding terminal of power source. Verify that the machine is properly grounded before connecting to the power source.

**WARNING :** *Never attempt to disconnect grounding terminal before disconnecting from the power source !*

### ADJUSTING MACHINE LEVELING

1. Place a precision level gauge on table, for checking the machine leveling condition.
2. Four leveling screws are located at the four bottom corners of the machine.
3. Adjust leveling, loosen the nut on each leveling screw, then turn the leveling adjustment screw until proper machine leveling is obtained.
4. Tighten the nut after leveling adjustment.

Fig. 1

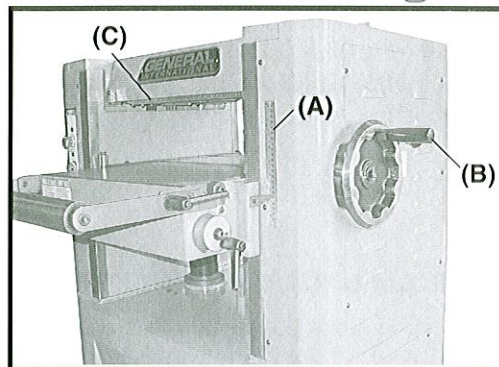




## CONTROL THE DEPTH OF CUTTING

The cutting depth scale is a combination ,of inch / metric scale (A), the cutting range is from 0 to 8"(204 mm). The distance between upward or downward of driving handle (B) is 0.059" (1.5mm) one complete turn.(Fig. 2) The maximum depth of cut on full width planning is 1/8". A limiter (C) is provide to limit the depth of cut. If the workpiece to be cut is less than 8" , the allowable maximum depth of cut no more than 1/4" in one pass.

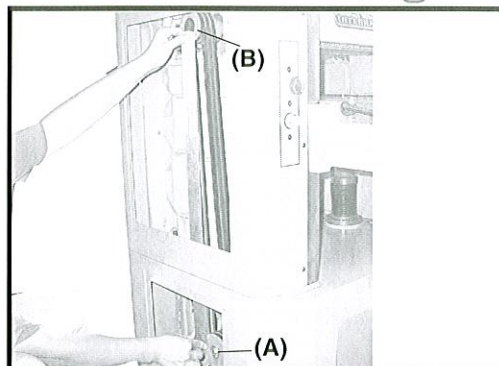
Fig. 2



## CHECKING PULLEY

To verify that motor pulley (A) is in line with the shaft pulley of (B), using the edge of a straight scale check to see if they are on-line with each other. (Fig. 3).

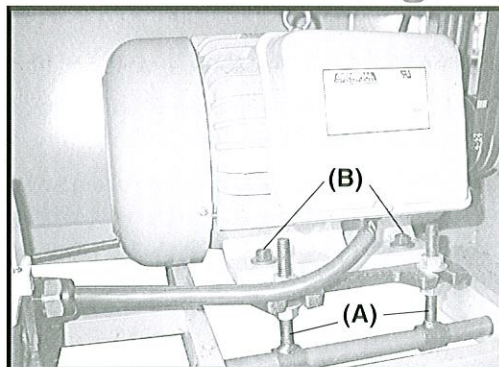
Fig. 3



## ADJUSTING MOTOR MOUNT

If motor pulley (A) and shaft pulley (B), are not on-line loosen screw (B) as shown in (Fig. 4), move motor to left and right until adjusted to proper position and tighten the screw again.

Fig. 4



## ADJUSTING BELT TENSION

Use the two bolts (A) to adjust the belt tension (Fig.4). When achieved proper position of adjustment , tighten bolts to hold in place.

**NOTE:** The proper belt tension is appr. 1/4" deflection in the center span of the belts using light finger pressure.

Fig. 5

## FEED ROLLER SPEED RATE

The rate of speed is transmitted by shift gears located in gear box. The shift gear handle (Fig.5) performs with three different methods of speed by using the shift handle to pull or push.

Position B: feed roller is functioning on 28 FPM speed rate.

Position C: feed roller is functioning on 0 FPM speed rate.

Position D: feed roller is functioning on 22 FPM speed rate.



## CONNECTING DUST COLLECTOR

Connect dust collector system to hood of machine, located at the back of machine. The dust collector will collect all dust and particles while planing in process, this system will give a clean and safe working environment. (Fig.6)

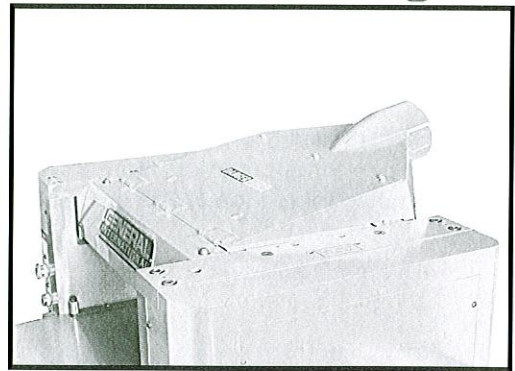


Fig. 6

## FEED ROLLER PRESSURE ADJUSTMENT

The pressure of the feed roller will depend on the pressure set by the springs, and screws. To adjust the pressure, you must loosen or tighten the lever(A) There are two sets of springs on both ends of the feed roller, to ensure great results make sure both sides are at the same level pressure. (Fig.7)

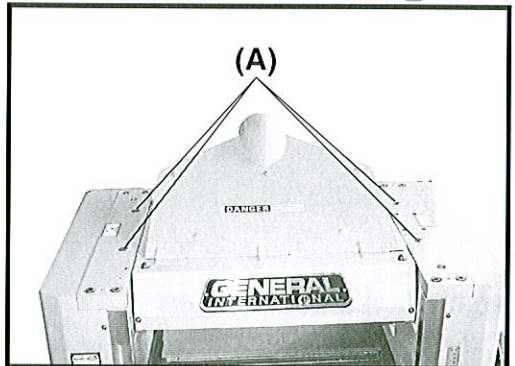


Fig. 7

## ADJUSTING TABLE ROLLER

To reduce friction between stock and table, two table rollers have been assembled on machine. Adjustments will be needed when planing with the different types of wood. The table rollers on the planer are set for average planning and are parallel to the table surface. If not, follow the procedures:

1. Disconnect machine from power source.
2. Place a straight edge across two rollers.
3. Loosen nut (A) and adjust screw (B) to raise or lower the roller. Rollers must be adjusted on both sides.(Fig.8)
4. Table rollers must always be parallel to the table.
5. Make sure both rollers are at same height. There must be no slant between roller and table.

Use the control lever you can let rollers upward or downward from the table. As a general rule, rollers must be set high, when planing rough wood. Rollers must be adjusted low, when planing smooth wood.

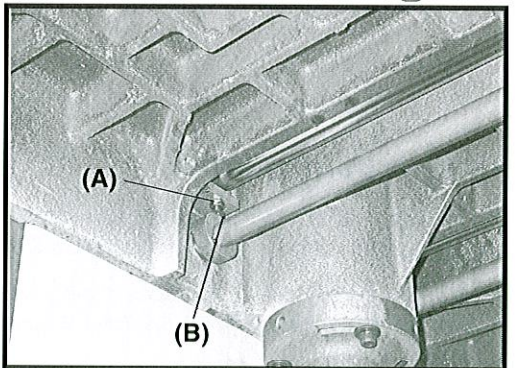


Fig. 8

## CHECKING AND REPLACING KNIVES

Place knife gauge as shown in (Fig.9). Knife gauge must be set on fix position when adjusting, and proceed as follows:(Fig.10)

- Loosen six hex screws (D) on the knife locking bar(C) and be sure that knife doesn't have any pressure or stoppage from out side.
- Spring (E) will raise knife (F) naturally making knife(F) contact with point (B), this would mean that the knife is in the proper position.
- Tighten the six hex screws (D) on the knife locking bar (C) evenly. Follow the same procedures to adjust the other three.

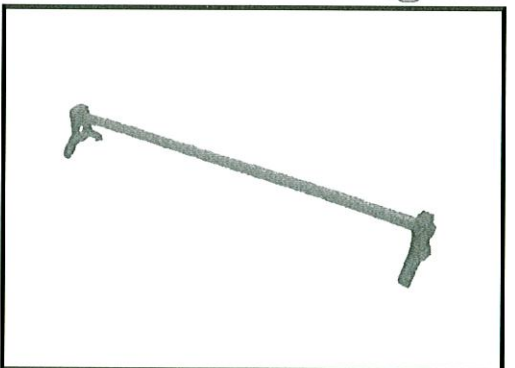


Fig. 9



## ATTENTION!

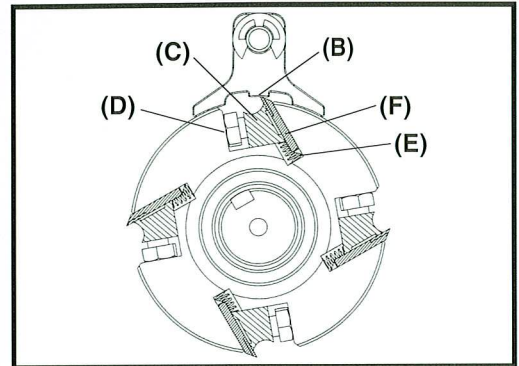
**ALWAYS DOUBLE CHECK THAT THE DIRECTION OF THE KNIVES ARE CORRECT, AFTER YOU FINISH REPLACING THEM !  
VERIFY THAT ALL HEX SCREWS ARE FIXED TIGHTLY!**

### REMOVING KNIVES

When removing knives proceed as follows: (Fig. 10)

1. Loosen screw (D) and make sure that knife doesn't have pressure or stoppage from the outside.
2. Remove knife (F).
3. Remove knife locking bar (C).
4. Remove the two springs (E).
5. Follow same procedures to remove other knives.

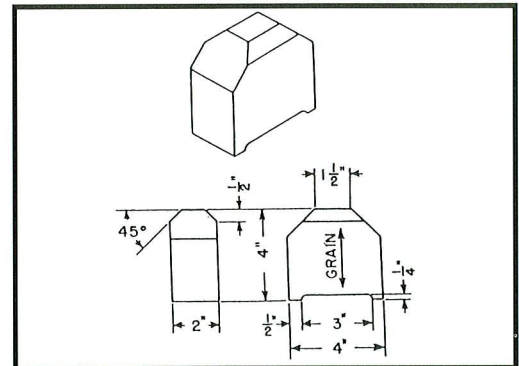
Fig. 10



### ADJUSTMENTS

- Before starting any adjustments, disconnect the machine from the power source. The manufacturer has adjusted all machines before shipment. Verify that the screws are properly tightened. The only time you will have to adjust your machine is when it has been functioning for a long time. The adjustment will have to be made to adjust the precision of the machine. Always check the adjustments before starting on a new project, this will save you time and money. To check you will need the following supplies.
- Straight scale
- Feeler gauge
- Home made gauge block of hard wood, with the dimensions as shown in Fig.11

Fig. 11



### ADJUSTING LEVELING BETWEEN TABLE AND EXTENSION ROLLER

1. Disconnect the machine from power source.
2. Place straight edge through machine so that it lies across both table and roller. (Fig. 12)
3. If table and extension roller are not aligned, then loosen the two bracket lock levers, located at right and left sides of the bracket.
4. Loosen the screw that tightens the eccentric knob.
5. Turn the eccentric knob until the extension roller just touches the straight edge.
6. Tighten screw.
7. Adjust the other side of extension roller in the same way.

Fig. 12

